
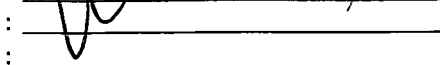


Date: Tuesday, 29/04/2008 11:53:10 AM
 User: Melanie Fauteux

Process Sheet

OK

| | | | |
|-----------------------|-------------------------------------------------------------------------------------|------------------|------------------------------|
| Customer | : CC-DAR01 Dart Aerospace Ltd. | Drawing Name | : LEG |
| Job Number | : 38889 | | |
| Estimate Number | : 10804 | | |
| P.O. Number | : | Part Number | : D37733 |
| This Issue | : 29/04/2008 S.O. No. : | Drawing Number | : PROTOTYPE |
| Prsht Rev. | : NC | Project Number | : |
| First Issue | : 29/04/2008 Type : R & D SM/MED FAB | Drawing Revision | : A 08.04.23 |
| Previous Run | : 38880 | Material | : |
| Written By | :  | Due Date | : 16/05/2008 Qty: 4 Um: Each |
| Checked & Approved By | :  | | |
| Comment | : | | |

Additional Product

PROTOTYPE

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

MAKE PER DRWG D3773 REV A

FF 08-05-12 (4)

2.0

M304TR1000W065

304 RD Tube 1.0" x .065W



Comment: Qty.: 1.0500 f(s)/Unit Total: 4.2000 f(s)
 304 RD Tube 1.0" x .065W

M 107952

FF 08-05-12 (4)

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
 APPROVAL

08-05-14

PTO

LAST PAGE

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

GIVE TO CHRIS P-ENG

CHARGE TO JOB #00196

Cpl 08-05-22

FOR ENGINEERING USE ONLY

CERTIFICATE OF CONFORMITY
 REQUIRED

5.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

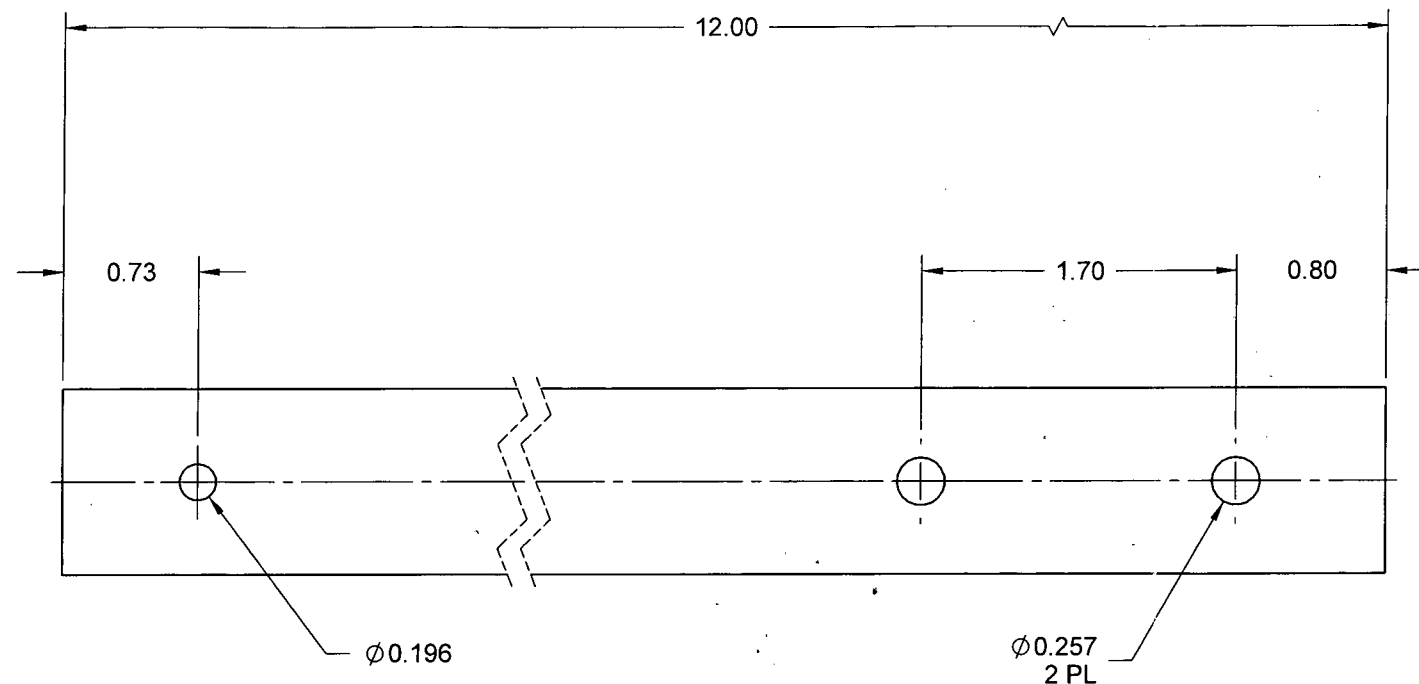
08-05-29 Prototype

Job Completion

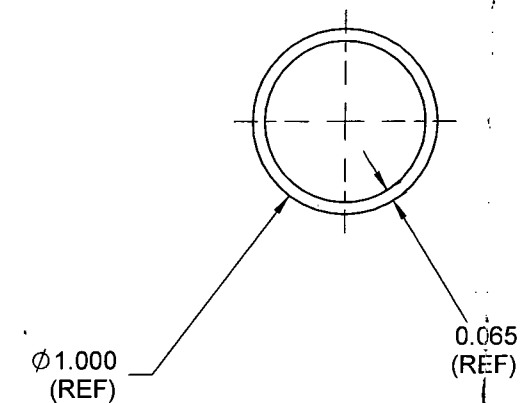


00196A

MF 08-05-20



D3773-3 LEG



PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

08.04.23

NOTES:

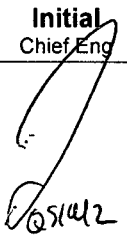



- 1) MATERIAL: AISI 304/316 SS TUBING 1.00" OD X 0.065" WALL (REF DART SPEC M304TR1.000X.065)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

| | | | |
|------------|-----------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN | HS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | HS | | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3773 | SHEET 3 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | HEADREST ADAPTER | 1:1 |
| DATE | 08.03.26 | <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|----------|----------------------------------------------------------------------|------------------------------------------------------------------------------------|---------------------------------------------------------|----------------|-------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 08/05/14 | # 410 | one leg scrap. end has been damaged. egg shaped RL was DROPPED |  | Scrap and Destroy and Replace Qty (10) B# M107952 | FF 08/05/14 |  |  |  |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Receiving Report

Date: 8/07
Supplier: MPGNA

Batch No: M/107952
Dart P/O: 6270

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☐ No ☒
Receipt: Cash ☐ Cr ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐
Waybill Attached: Yes ☐ No ☒
Shipment Complete: Yes ☒ No ☐ N/A ☐
QC6 Inspection done 8/07 N/A ☐
Work Order N/A ☒

Discrepancies

| Part Number | Description | Quantity Ordered | Quantity Received | Quantity Returned | Quantity Short | Comments |
|-------------|-------------|------------------|-------------------|-------------------|----------------|----------|
| | | | | | | |
| | | | | | | |
| | | | | | | |

Initials of receiver (if shipment OK) Level 12

Production/Admin:
Date: 08/05/08
Received/Costing: RCP 7826
Initial: CL

Location

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

Heat # 168/12-3

RECEIVED MAY 13 2008

Sub-Total
G.S.T.

1090.00
54.50

TOTAL →

1144.50

FRAIS D'ADMINISTRATION DE 1½% PAR MOIS (18% PAR ANNÉE) SUR COMPTE PASSÉ DÙ.
LE PRÉSENT CONTRAT SERA RÉGI PAR LES LOIS DE LA PROVINCE DE QUÉBEC ET COMME
AYANT PRIS NAISSANCE DANS LE DISTRICT JUDICIAIRE DE MONTRÉAL.
ADMINISTRATION CHARGES OF 1½% PER MONTH (18% PER YEAR) ON OVERDUE ACCOUNTS.
THE PRESENT AGREEMENT SHOULD BE GOVERNED BY THE QUEBEC LEGISLATION AND SHOULD
BE CONSIDERED AS HAVING ORIGINATED IN THE JUDICIAL DISTRICT OF MONTREAL.

C 6 8 2 5



Shanghai Huaerde Stainless Steel Pipe Manufacture Co., Ltd.

Chihua Road, Shanghai Chemical Industry Park(Section B)
Fengxian District, Shanghai.201417 China

A PED& AD-W2 Certified Company

Mill Test Report

HED31569-02

According to EN10204 - 3.1



Certificate No. 0120/0103/06/0247

| | | | |
|--------------------|---------------------------------------------------------|------------------------|----------------------------------------------------------------------------------------|
| Customer Name | | Material Specification | ASTM A/SA-213 A269 NACE MR0176 TP304/304L OD 220 GRIT POLISHING |
| Purchase Order No. | 39569 | Heat Treatment | Solution Annealed in the temperature of 1040°C for 20 minutes and Quenched by water |
| Description | Cold Finished Seamless Austenitic Stainless Steel Tubes | Heat No. | YT071178 |

| ELEMENTS | C % | Mn % | P % | S % | Si % | Cr % | Ni % | Mo % | | Lot No. | Yield Strength | Tensile Strength | Elongation | Hardness HRB |
|------------------|--------------|-------------|--------------|--------------|-------------|---------------|--------------|---------|--|---------------|----------------|------------------|------------|-----------------|
| SPECIFICATION | Max 0.035 | Max 2.00 | Max 0.045 | Max 0.030 | Max 1.00 | 18.0 ~20.0 | 8.0 ~11.0 | | | YT071178 | Min.205MPa | Min.515 MPa | Min.35% | Max.90 |
| RESULTS(LADLE) | 0.019 | 1.22 | 0.013 | 0.008 | 0.48 | 18.20 | 8.21 | | | 07-09-27-94-1 | 286 | 566 | 47% | 75 |
| RESULTS(PRODUCT) | 0.017 | 1.09 | 0.014 | 0.009 | 0.47 | 18.23 | 8.17 | | | 07-09-27-94-2 | 275 | 547 | 49% | 73 |

C) Extend of material delivery

| Item No. | Quantity | Descriptions | Heat No. | Lot No. |
|----------|----------|----------------------|----------|-------------|
| 1 | 2500 ft | 1" x .049" x 20' | YT071178 | 07-09-27-94 |
| 2 | 2200 ft | 1" x .065" x 20' | YT071178 | 07-09-27-94 |
| 3 | 940 ft | 1" x .120" x 20' | YT071178 | 07-09-27-94 |
| 4 | 880 ft | 1 1/4" x .065" x 20' | YT071178 | 07-09-27-94 |
| 5 | 420 ft | 1 1/4" x .095" x 20' | YT071178 | 07-09-27-94 |

D) Hydrostatic Test, NDT and Dimensional check, etc.

| Testing Item | Details | Results |
|-------------------------------|-------------|--------------|
| Dimensional / Visual | ASTM A999 | Satisfactory |
| Hydrostatic Pressure test | ASTM A999 | Satisfactory |
| Flattening Test | ASTM A1016 | Satisfactory |
| Flaring Test | ASTM A1016 | Satisfactory |
| Inter-granular Corrosion test | ASTM A262 E | Satisfactory |

E) Steel Making Process

Electrical Furnace

F) Statement

1. No weld repair performed for billet and pipe

2.The Materials have been manufactured ,tested and examined in acc. with all the requirements of the ordered standards and we confirm that all test results are acceptable.

| | | | | | |
|------|-------------------|----------------|--------|------------------------|--|
| Date | November 24, 2007 | Mill inspector | Li Bin | Approved by QC manager | |
|------|-------------------|----------------|--------|------------------------|--|

